



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3143-3

Job Sheet 203211



Part No: D3143-3

Job Qty: 4 pcs

Part Name: Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/19

Job Tracking No:

Due Date: 11/20/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP REV:A 14.08.18 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	4 pcs	11/20/19	11/20/19	1.00	1.41	Doosan - 1		11/11/13
110	QC 2	4 pcs	11/20/19	11/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		11/11/13

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				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
120	QC 8	4 pcs	11/20/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
130	Packaging 3-1 - Stock - B4B	4 pcs	11/20/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
140	QC 21 - SA	4 pcs	11/20/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70

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52
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12/14/19

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NOV 15 2019

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21
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NOV 15 2019

Part Op 100 - (Doosan Lathe) 1-Turn as per Dwg D3143 and Folio F Folio Rev: 4A Dwg Rev: B 2-Debur
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - Identify as per dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.500	303 Round Bar 0.500"	.5600 ft (.14 ea)	100-Doosan - 1	529475

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R0.500	1	30	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clevis	0.440inches ± 0.010	0.450 0.430	Diameter	.439
2	Clevis	0.165inches ± 0.010	0.175 0.155		.165
3	Clevis	0.870inches ± 0.010	0.880 0.860		.865
4	Clevis	1.620inches ± 0.030	1.650 1.590		1.614
5	Clevis	0.750inches ± 0.010	0.760 0.740		0.745
6	Clevis	0.010inches ± 0.010	0.020 0.000	Radius	.010
7	Clevis	0.065inches ± 0.010	0.075 0.055		.060
8	Clevis	0.193inches + 0.005 - 0.001	0.198 0.192	Diameter	.194
9	Clevis	0.560inches ± 0.010	0.570 0.550		.554